ABSTRACT OF DISCLOSURE

The intermediate support brace is used to prevent bending or deflecting of a cylindrical work piece being machined by a journal turning lathe. A U-shaped frame is mounted to the journal turning lathe, and secured to the journal turning lathe by a first and second clamping means which secure the intermediate support brace to the guide rails of the journal turning lathe. A generally circular opening in the frame surrounds the cylindrical work piece, and the work piece is centered by a series of jacks. The clamshell lathe assembly is translated from a first end bracket to the intermediate support bracket. The clamshell lathe is then stopped; the intermediate support bracket is released and mounted downstream from the clamshell lathe assembly. The clamshell lathe assembly is then restarted and translated to a second end bracket.